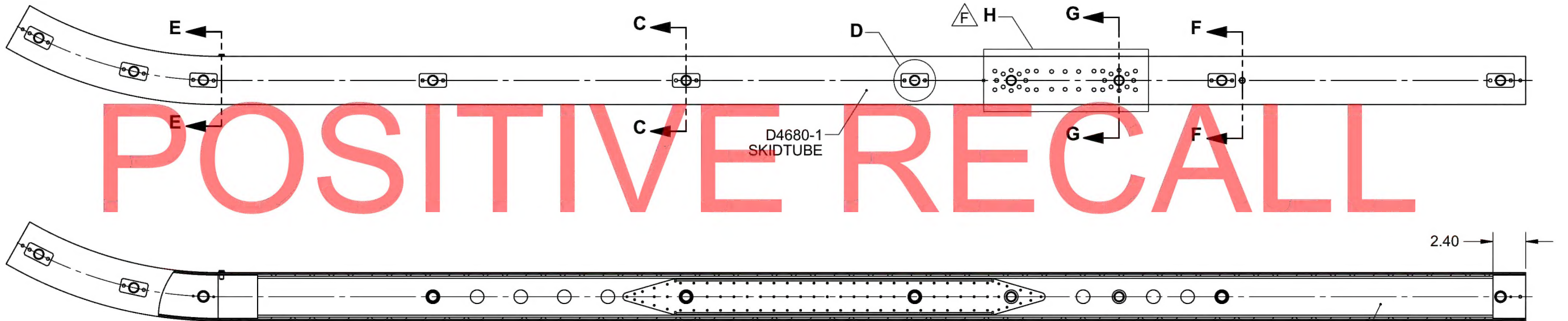
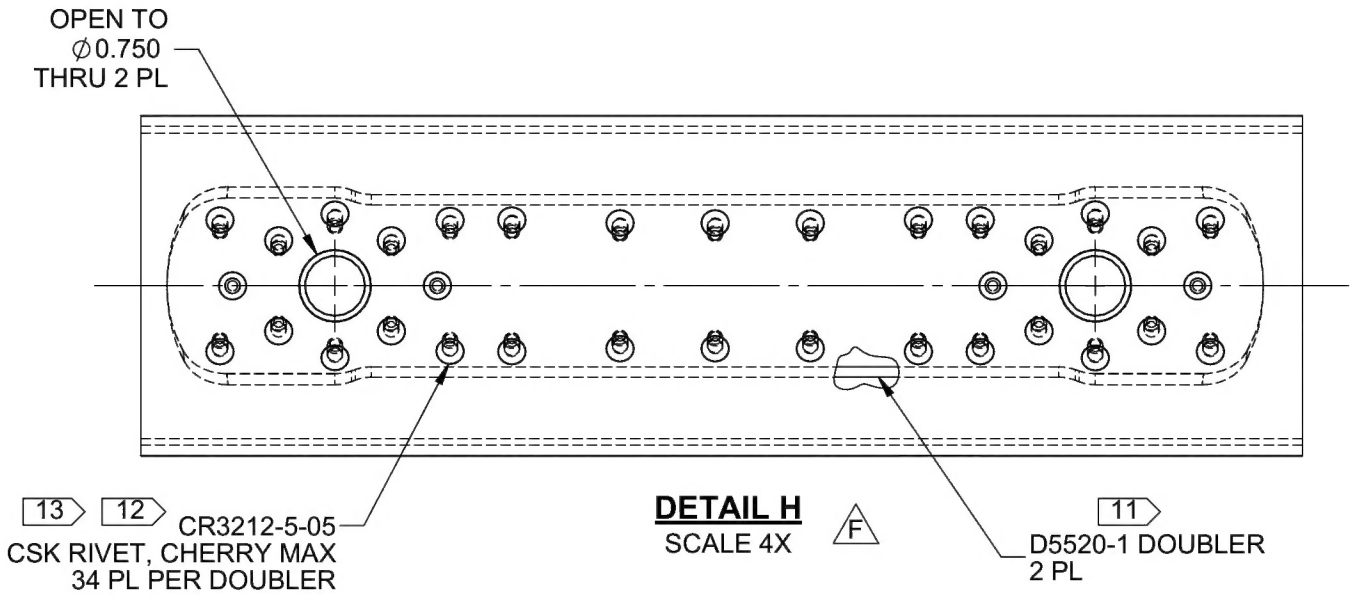


DESIGN	AP	<b>DART AEROSPACE USA, INC.</b> EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DP	<b>D4680</b>	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	<b>SKIDTUBE</b>	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4680-043	SKIDTUBE SUB ASSY
1	1	D4680-1	SKIDTUBE
2	1	D4681-041	WEB ASSY
3	8	D4686-1	SPACER
4	16	D4753-1	DOUBLER
5	2	D5304-1	CROSSBOLT SPACER
6	2	D5520-1	DOUBLER
7	3	AN3C4A	BOLT
8	32	MS20601AD4W3	RIVET, BLIND, CSK
9	3	NAS1149C0332R	WASHER
10	3	AELS-1032-130	INSERT
11	68	CR3212-5-05	CSK RIVET, CHERRY MAX

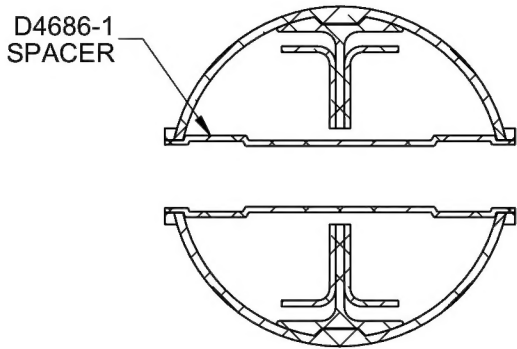


D4680-043 SKIDTUBE SUB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER DART QSI 005 4.1 PRIOR TO INSTALLING D4681-041 WEB.  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 18.6 lbs
- 8) SEAL ALL MATING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND  
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015
- 10) INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS
- 11) LOCATE THE D5520-1 DOUBLER USING THE Ø0.188 PILOT HOLES ON THE SKIDTUBE AND DOUBLER
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309
- 13) COUNTERSINK THE SKIDTUBE Ø0.286 X 100° (34 PL) AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS

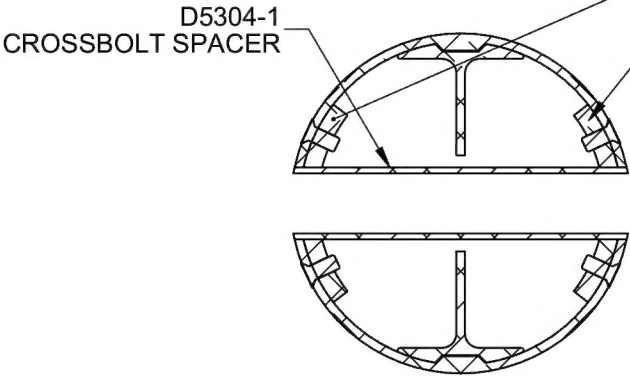
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DRAWN	AJS		
CHECKED	ML	DRAWING NO. D4680	REV. F SHEET 3 OF 5
MFG. APPR.	DP	TITLE SKIDTUBE	SCALE NTS
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D4686-1  
SPACER

- INSTALL D4686-1 SPACER AS FOLLOWS (8 PL)  
AFTER INSTALLING D4753-1 DOUBLERS PER DETAIL D
1. INSERT D4686-1 SPACER
  2. SWAGE TO  $\varnothing 0.650 +0.010/-0.000 \times 1.0$   
DEEP PER QSI 002
  3. TRIM/GRIND FLUSH PER QSI 002

10 SECTION C-C  
SCALE 4X  
8 PL

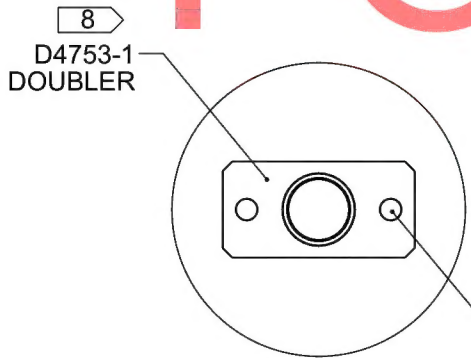


D5304-1  
CROSSBOLT SPACER

- D5520-1 DOUBLER  
REF
- INSTALL D5304-1 SPACER AS FOLLOWS (2 PL)
1. INSERT D5304-1 SPACER
  2. SWAGE TO  $\varnothing 0.565 +0.005/-0.000 \times 1.0$   
DEEP PER QSI 002
  3. OPEN THRU HOLE TO  $\varnothing 0.625$

SECTION G-G  
SCALE 4X  
2 PL

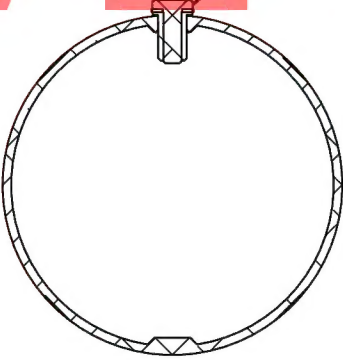
POSITIVE RECALL



8 D4753-1  
DOUBLER

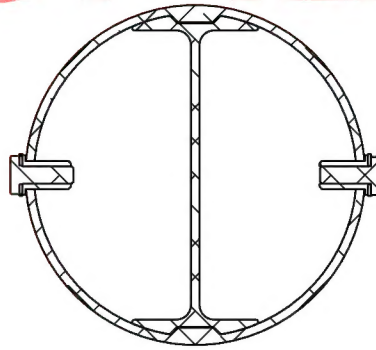
MS20601AD4W3  
RIVET, BLIND, CSK  
2 PL

DETAIL D  
16 PL (BOTH SIDES)  
SCALE 4X



AN3C4A BOLT  
NAS1149C0332R WASHER  
AELS-1032-130 INSERT

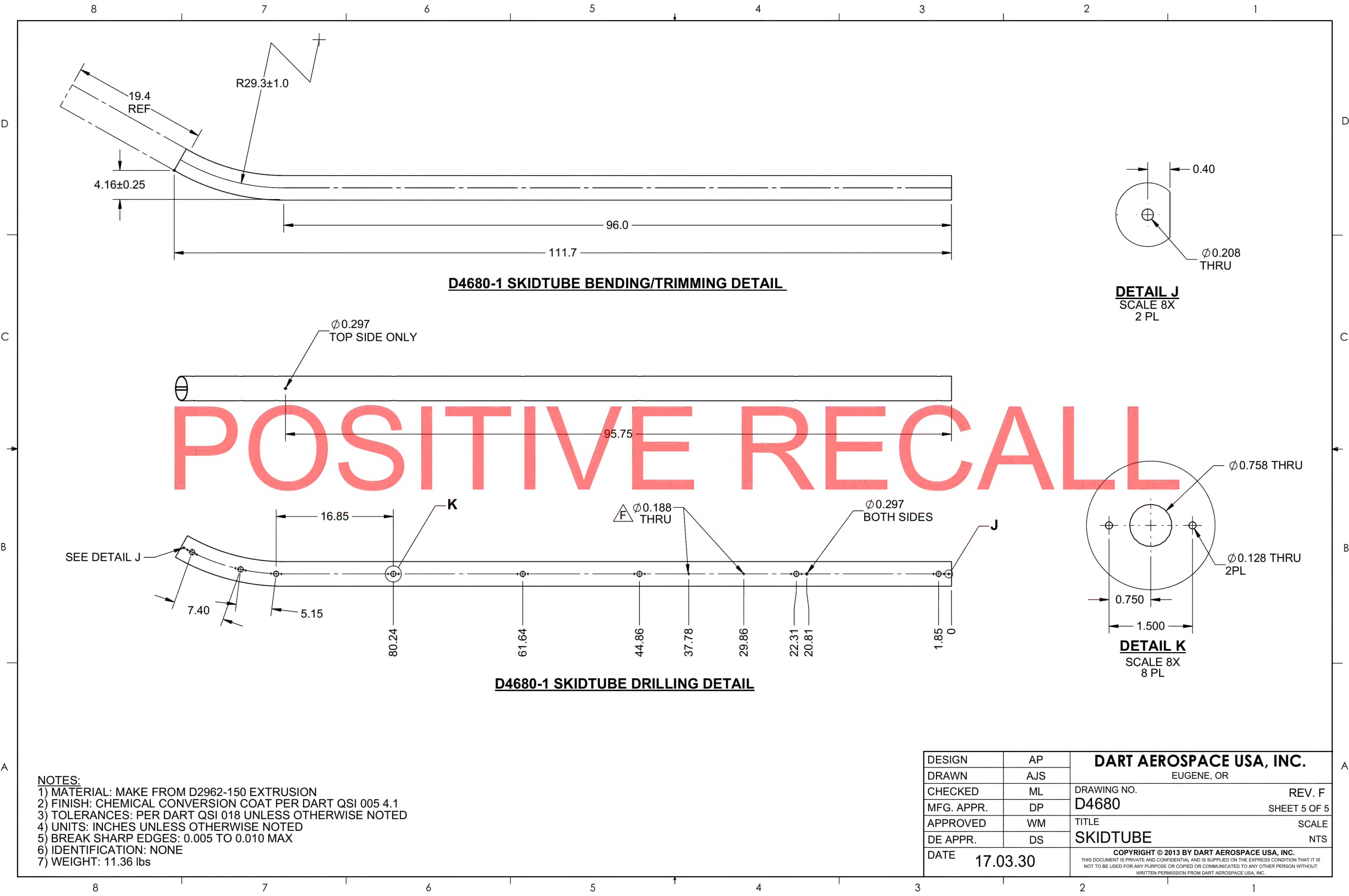
SECTION E-E  
SCALE 4X



AN3C4A BOLT  
NAS1149C0332R WASHER  
AELS-1032-130 INSERT  
2 PL

SECTION F-F  
SCALE 4X

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MFG. APPR.	DP	D4680	SHEET 4 OF 5
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- NOTES:
- 1) MATERIAL: MAKE FROM D2962-150 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 11.36 lbs

DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DP	D4680	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
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